

Date: Thursday, 02/10/2008 8:23:58 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (EC 135)
Job Number	: 42380		
Estimate Number	: 10536		
P.O. Number	:	Part Number	: D135692011
This Issue	: 02/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3049 REV A1
First Issue	: / /	Project Number	: N/A
Previous Run	: 41995	Drawing Revision	: A1
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 15/10/2008
Checked & Approved By	: <u>JLD 08-10-02</u>	Qty:	10
Comment	Est Rev:C 04.02.17 Blank size changed, Tolerance added Step 3 KJ/JLM Est Rev:D 08-04-16 Added Step 2 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.10.08



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

Solid 10

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



Comment: MFG ENGINEERING

Program Batch Number

JLD 08.10.02

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 5.6280 sf(s)/Unit Total: 56.2800 sf(s)

blank: 16.00" x 23.50" x 1.00" thick (+0.030/-0.000)

per DSK086-9

Material: Black UHMW 1"(MUHMWB10)

Batch: 109186 B 2-10-2

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

3-Deburr

JLD 08/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/10/05

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/10/06 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

8.0

D2182B

Rubber Cushion



Comment: Qty.: 2.0000 f(s)/Unit Total: 20.0000 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2182B060

(6.00")

Rubber Cushion

39986

SS 08/10/07 (X10)

9.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 D2274

Radius Block

39238

SS 08/10/07 (X10)

10.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2519

Clamp

34306 X22

SS 08/10/10
18X
SS 08/10/07 (X10)

11.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 D2529

Washer

38188

SS 08/10/07 (X10)

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Job Number:



Seq. #: Machine Or Operation: Description:

12.0 AN415A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 AN4-15A Bolt M108077

13.0 AN960JD416 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 AN960JD416 Washer M108827

14.0 MS21042L4 Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 MS21042L4 Nut (or -4) M108145

15.0 QS100M24S Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 D3049-1(ref) Bearpaw 42380
4 QS100M24S Clamp M109389 x27
1 Paperwork package from Step 2(ref)

16.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-692-011

Location:

PPP Rev:

Rev C

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42380
Description: Bearpaw		Part Number: D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	.260	✓			
B	0.93	+/-0.030	.930	✓			
C	0.40	+0.030/-0.000	.400	✓			
D	2.00	+/-0.030	2.000	✓			
E	10.250	+/-0.010	10.250	✓			
F	4.540	+/-0.030	4.540	✓			
G	5.88	+/-0.030	5.88	✓			
H	0.38	+/-0.030	.380	✓			
I	11.50	+/-0.030	11.50	✓			
J	0.07 x 45°	+0.030/-0.010	.070	✓			
K	0.44 - 0.47	+/-0.000	.44	✓			
L	R0.25	+/-0.030	.250	✓			
M	0.38	+/-0.010	.380	✓			
N	0.95	+0.030/-0.010	.951	✓			
O	0.69	+/-0.030	.690	✓			
P	0.20	+/-0.030	.200	✓			
Q	23.00	+/-0.030	23.000	✓			
R	0.25 x 45°	+/-0.030	.250	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 08/10/05	Date: 08/10/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

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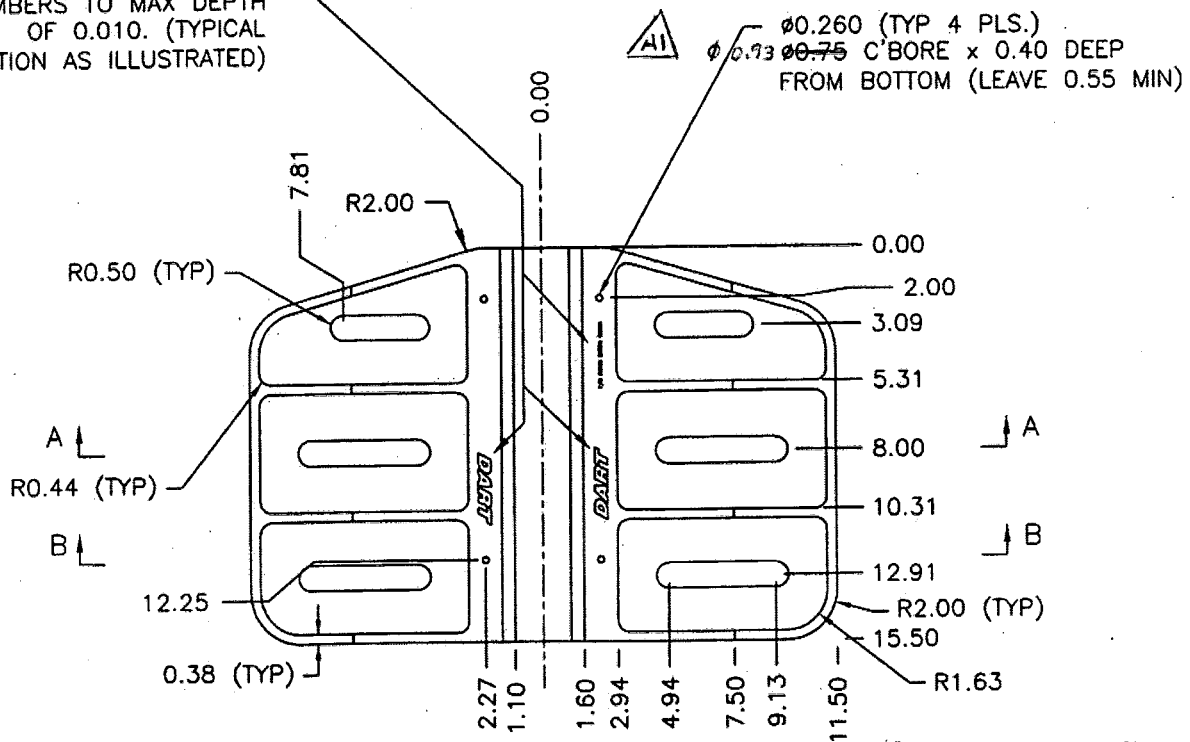
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	# 03.01.13	Ø 0.73 WAS Ø 0.75	

RELEASED
01.10.24 #

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42380

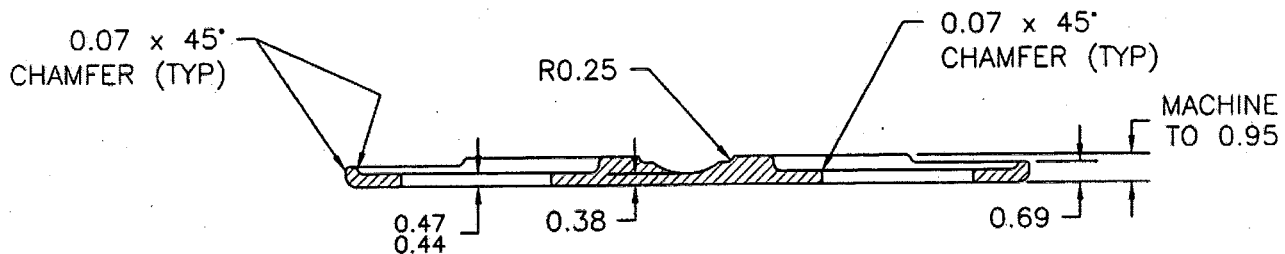
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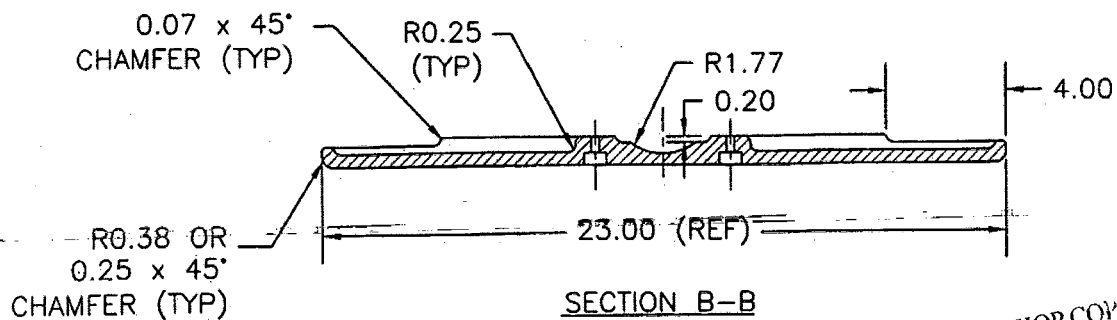


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 *[Signature]*



SECTION A-A



SECTION B-B

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WORK ORDER
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